

Stitch Oct 14

Work Order ID 61824



Page 1

Tuesday, September 07, 2010 12:32:50 PM

Item ID: D412-630-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 9/7/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D412-630-014 CHG006

8/10/09/23

10-9-23

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801
2-Deburr and bevel ends for welding

10-09-15

1

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/09/16

40

361824

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld arms and end caps as per Dwg D2801 & QSI 004. Inspect for foreign objects as per QSI 024. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>M112860</u> <u>M114877</u>								
	2-Grind end cap welds flush as per Dwg D2801								
140 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10.09.16

10.09.20

8/10/09/20

AI
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
165 10.09.20	QC3 => JH 10/09/20								
170 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Deburr and bevel aft end for welding.								
	2-Weld as per Dwg d2801 a/r AL ROD Batch: M112860								
	3-Grind end cap welds flush as per dwg D2801								
180 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

10.09.20

X1 0

10.09.21

1

1

10.09.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 10/09/21		(X1) 24			PFO →
200 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo And chemical conversion coat as per QSI005 4.1	0.00 0.00		22 10/09/21		(X1)			
210 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 195221 Memo START TIME: 8:10 OVEN TEMPERATURE: 320° FINISH TIME: 8:40	0.00 0.00		bl 10-9-22		(1)			

220
10.09.22

Wing Walk Batch: M115025 10/09/22 1

Dart Aerospace Ltd

W/O: 61824		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-21	(91)	Press fit bushing D2808 into arm per drawing D2808 D2802 <u>M46738</u>	EB	10/09/21	2	C 10-09-21	

Part No: D412-630-014 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 510/09/21 ②

240

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EP 510/09/21 ②

250

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D412-630

EP 510/09/21 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/13/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/09/23



270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/9/23

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/10/09/23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 10/13/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-630-014

Location: _____

PPP Rev: C

10/9/23

300

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/09/24

MF
10-9-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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[illegible]**Required Date:** 10/13/2010

Required Qty: 1.00

[illegible]

1



10.09.15

48

1



1
10.09.14

79

19

60

3.0000



2 *PK* 10.09.15

3

3

79.0000



1 *Dr* 10.09.21

• 79

19

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 61824

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Parent Item Name: Heli-Access-Step RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

D2012-107 Manufactured No



Clevis



Each

14.0000

1



1
EP 10/09/22

Location

Loc Qty

Loc Code

ST004

14

46634

14

D2022-101 Manufactured No



Spacer



Each

72.0000

2



2
EP 10/09/22

Location

Loc Qty

Loc Code

ST504

72

50746

23

52325

49

D2652 Manufactured No



Bushing



Each

273.0000

4



2
4
EP 10/09/22

Location

Loc Qty

Loc Code

FG

44

31985

44

ST020

229

61197

28

61645

201

D2803-042 Manufactured No



Bracket Assembly



Each

0.0000

1



1
B61725
EP 10/09/22

D2804-042 Manufactured No



Bracket Assembly



Each

1.0000

1



1
EP 10/09/22

Location

Loc Qty

Loc Code

ST150

1

46640

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 61824

Parent Item: D412-630-014

Parent Item Name: Heli-Access-Step RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

D2807-041

Manufactured No



Door prop



Each

22.0000

2



2
9/5/09/22

Location

Loc Qty

Loc Code

ST023

22

60540

2

60771

20

D2810-1

Manufactured No



Strut



Each

13.0000

1



1
9/5/09/22

Location

Loc Qty

Loc Code

Mezz

13

35310

3

39546

10

D2813

Manufactured No



Washer



Each

39.0000

2



2
9/5/09/22

Location

Loc Qty

Loc Code

ST025

39

61051

39

AN3-20A

Purchased No



Bolt



Each

72.0000

2



2
9/5/09/22

Location

Loc Qty

Loc Code

ST352

72

105125

32

115371

40

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 61824

Parent Item: D412-630-014

Parent Item Name: Heli-Access-Step RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-10A Purchased No 240 Each 97.0000 1 1
Bolt

Location	Loc Qty	Loc Code
ST356	97	
113422	1	
114523	96	

AN8-16 Purchased No 240 Each 40.0000 2 2
Bolt

Location	Loc Qty	Loc Code
ST345	40	
105545	40	

AN310-8 Purchased No 240 Each 0.0000 2 2
Nut

MS24665-285 Purchased No 240 Each 115.0000 2 2
Cotter Pins

Location	Loc Qty	Loc Code
ST309	115	
9003	115	

AN960JD10 NAS1149D0363J Purchased No 240 Each 6.0000 4 4
Washer

Location	Loc Qty	Loc Code
ST	6	
107715	6	

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Parent Item Name: Heli-Access-Step RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No



Washer

AN960JD816



1/2" washer, Alum

4 M115622

(1X)

Purchased No

MS21042L3



Nut

Purchased No

MS21042L4



Nut

Purchased No

Location

ST348

106043

Location

ST300

114523

114784

Location

ST300

113422

114523

114718

114784

115108

Loc Qty

135

135

Each

Loc Qty

2103

109

1994

Loc Qty

2263

68

28

16

231

1920

Loc Code

2,103.000

Loc Code

2,263.000

Loc Code

1

1

1



4

4



4

4



1

1



Ep 510/09/22

Ep 510/09/22

Ep 510/09/22

Ep 510/09/22

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Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

MS24693-S280

Purchased

No



Screw

240

Each

36.0000

2



2
9/10/09/22

Location

Loc Qty

Loc Code

ST288

36

105125

36

270

Each

72.0000

2



2
10/9/23sf

D2022-101

Manufactured

No



Spacer

Location

Loc Qty

Loc Code

ST504

72

50746

23

52325

49

270

Each

19.0000

2



2
10/9/23sf

D2806-1

Manufactured

No



Bushing

Location

Loc Qty

Loc Code

ST025

19

46609

19

270

Each

19.0000

2



2
10/9/23sf

D2806-3

Manufactured

No



Bushing

Location

Loc Qty

Loc Code

ST025

19

46737

19

270

Each

5.0000

1



2
10/9/23sf

D3563-10

Manufactured

No



Eyebolt

Location

Loc Qty

Loc Code

ST070

5

29371

5

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Parent Item Name: Heli-Access-Step RH

Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-7A

Purchased

No

270

Each

191.0000

1



Bolt



10/9/23 SP

Location

Loc Qty

Loc Code

ST356

191

113226

141

115373

50

1

AN4-15A

Purchased

No

270

Each

323.0000

2



Bolt



2 11/10/148 10/9/23 SP

Location

Loc Qty

Loc Code

ST338

112

ST358

211

112905

12

114784

21

115108

78

115371

100

AN5-15A

Purchased

No

270

Each

111.0000

2



Bolt



2 10/1/23 SP

Location

Loc Qty

Loc Code

ST339

111

115159

61

115316

50

2

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

0.0000

8



Washer



8 11/5/22 10/9/23 SP Pro →

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Dart Aerospace Ltd

W/O: 61824		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/9/23	# 100	perm. change update Qty For A1260JD416 to 78 Per kit ADD copy of updated Bom For Ref.	Er	10.10.24			5 10/2/23

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Start Date: 9/7/2010

Required Date: 10/13/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD516 NAS1149D0563J Purchased No

270

Each

34.0000

4

4



Washer



1114742 10/9/03

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

MS21042L4

Purchased

No

270

Each

2,263.000



4 10/9/03 P10 →

Nut

Location

Loc Qty

Loc Code

ST300

2263

113422

68

114523

28

114718

16

114784

231

115108

1920

MS21042L5

Purchased

No

270

Each

617.0000

2



Nut



2 10/9/03

Location

Loc Qty

Loc Code

ST139

117

114813

117

ST300

500

115156

500

Tuesday, September 07, 2010 12:32:55 PM

Shop Packet Print

Page 8

W/O: 61824		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/13	#100	update Qty For MS2104264 to (x4) per kit ADD copy of update form for Ref.	E	10.10.24			S 10/4/23

Part No: D412-630-014 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

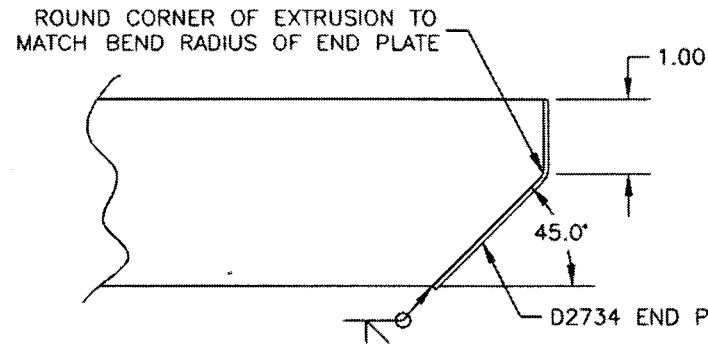


DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE		D2801	REV. A
00.11.03		TITLE	SHEET 1 OF 1
		STEP WELDMENT	SCALE
			NIS
A	00.11.03	NEW ISSUE	
A1	03.08.15	7.50 WTS 7.13	

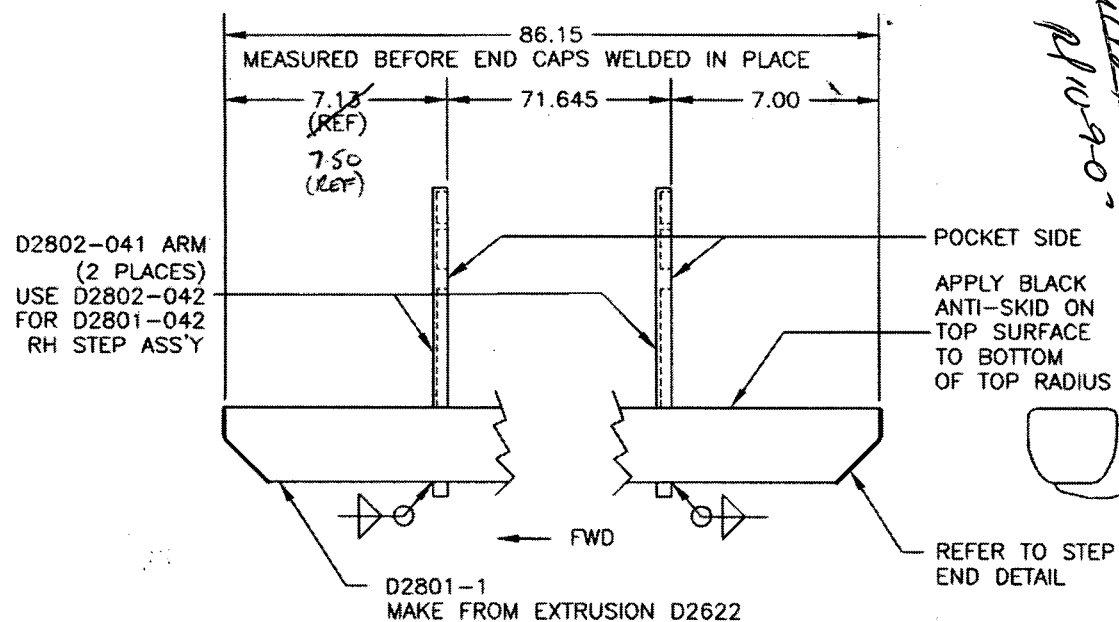
RELEASED
00.11.13

UNCC
SUBJ
ORDER
NOTICE
COPY
NO. 41529
P10-900

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

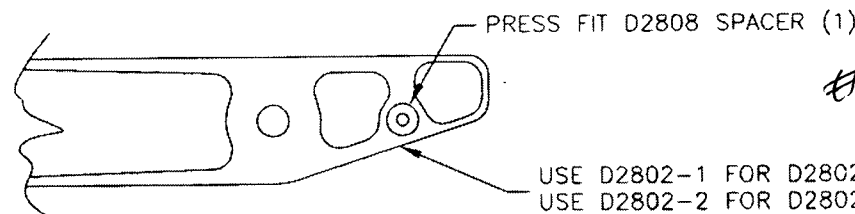
NOTE: Date & initial all entries

DART

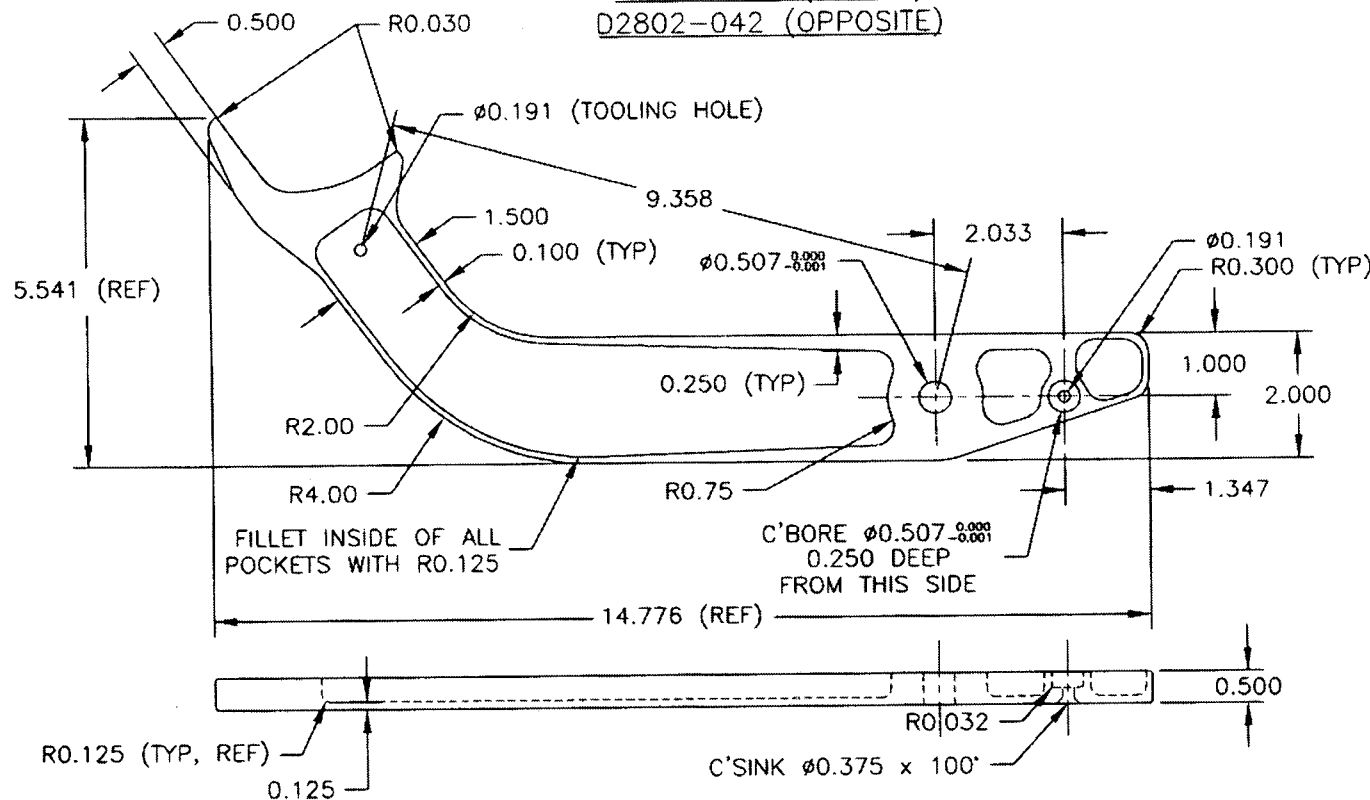


DESIGN	DRAWN BY	DART AEROSPACE LTD
#	#	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	#	D2802
DATE	TITLE	REV. A
00.11.03	ARM	SHEET 1 OF 1
		SCALE
		1:3
A	00.11.03	NEW ISSUE

RELEASED
00.11.03



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

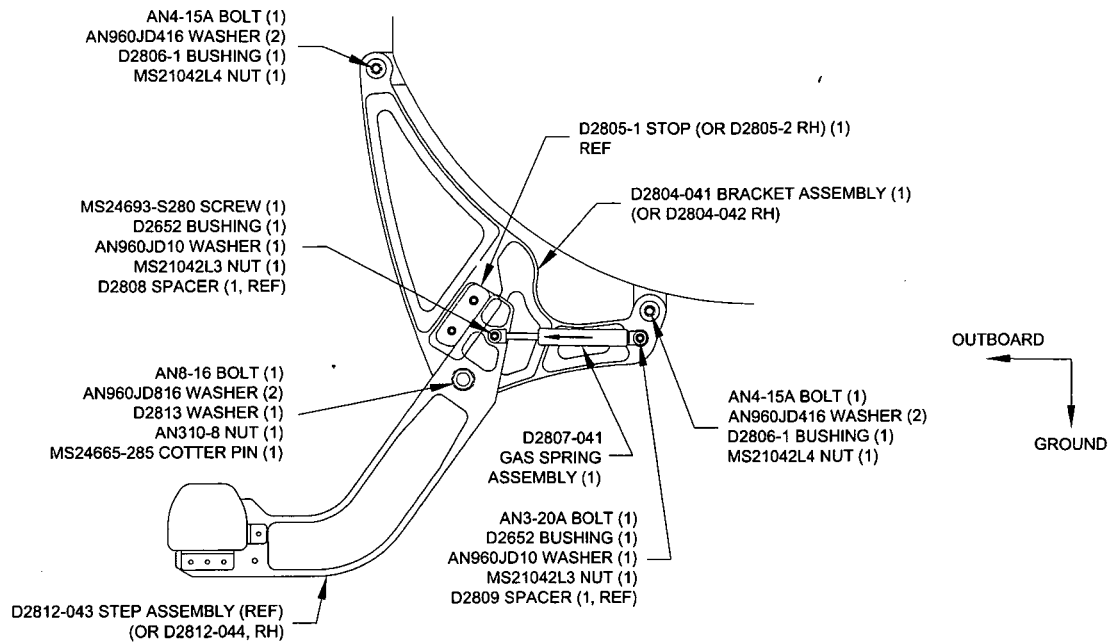


FIGURE 6 – STA 155.06 for D412-630-011/-012 Heli-Access-Step™ Installation (View rotated 90° CW)

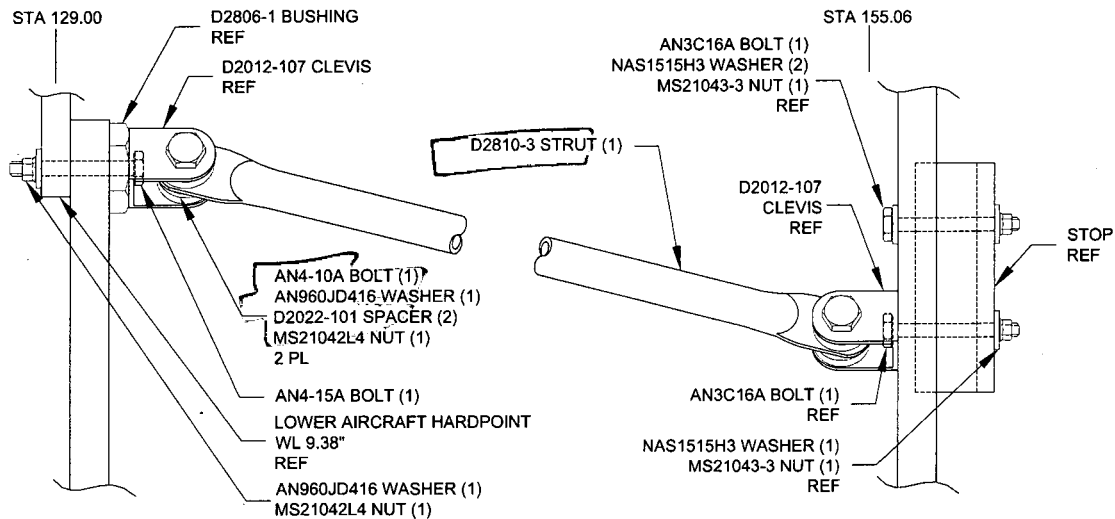
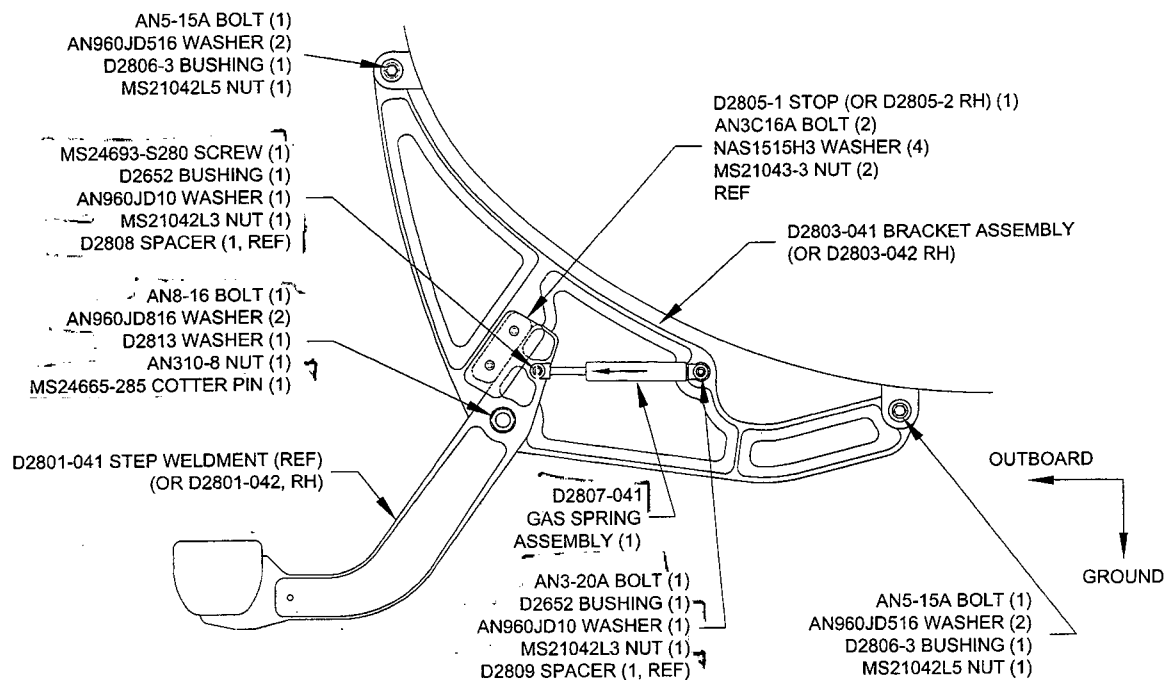
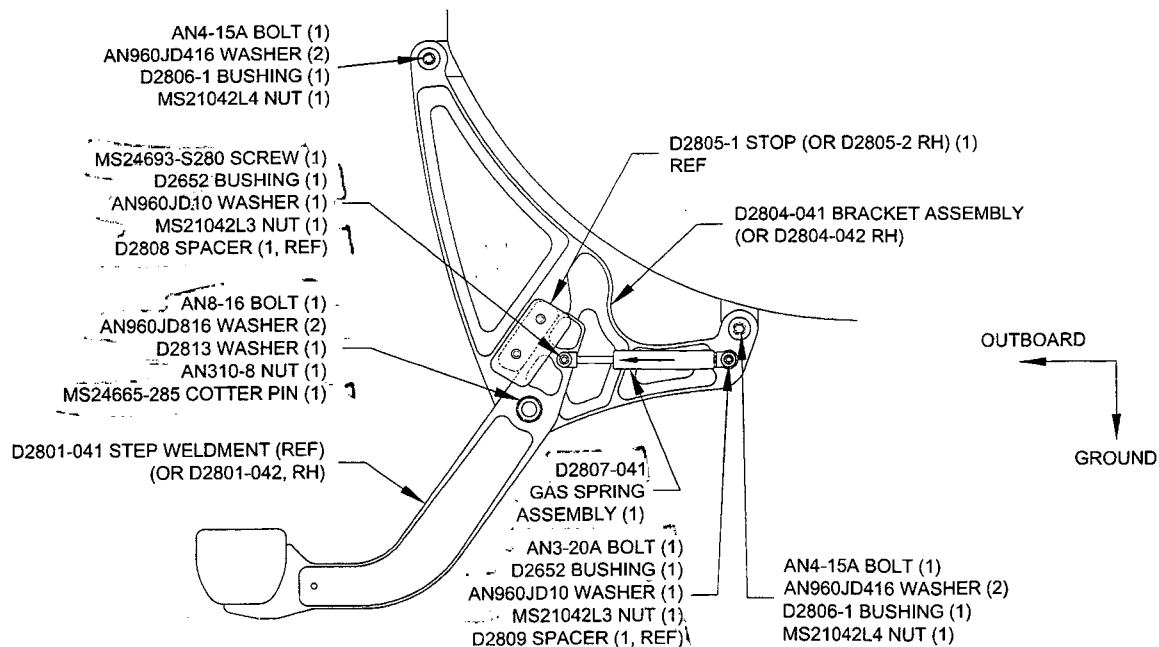


FIGURE 7 – Strut Detail for D412-630-011/-012 Heli-Access-Step™ Installation (NOT TO SCALE)

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Revision: **M**
Date: 08.12.12

D412-630-013/-014 Heli-Access-Step™ Installation**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

Qty -013	Qty -014	Qty -043	Qty -044	Part Number	Description
X				D412-630-013	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-014	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-043	STEP ASSEMBLY LH
	1		X	D412-630-044	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
2	2	2	2	D2022-101	SPACER
		4	4	D2652	BUSHING
		1		D2801-041	STEP WELDMENT LH
			1	D2801-042	STEP WELDMENT RH
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
		1	1	D2810-1	STRUT
		2	2	D2813	WASHER
1	1			D3563-10	EYEBOLT
		2	2	AN3-20A	BOLT
1	1			AN4-7A	BOLT
		1	1	AN4-10A	BOLT
2	2			AN4-15A	BOLT
2	2			AN5-15A	BOLT
		2	2	AN8-16	BOLT
		2	2	AN310-8	NUT
		2	2	MS24665-285	COTTER PIN (OR AN380-3-4)
		4	4	AN960JD10	WASHER
8	8	1	1	AN960JD416	WASHER
4	4			AN960JD516	WASHER
		4	4	AN960JD816	WASHER
		4	4	MS21042L3	NUT (OR MS21042-3)
4	4	1	1	MS21042L4	NUT (OR MS21042-4)
2	2			MS21042L5	NUT (OR MS21042-5)
		2	2	MS24693-S280	SCREW (OR MS24694-565)